

Work Order ID 66764

Friday, February 25, 2011 2:17:54 PM



Page 1

Item ID: D2535

Accept



Setup Start



Revision ID:

Item Name: Spring

Stop



Start Date: 2/25/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4-02-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2535

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13566 ☐ Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

CL 11/02/28 (50)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

P4/3/4 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check dims to dwg

S. 103/07

counted
(54)

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 504

0.00

Memo

0.00

Packaging

11/3/7 SL 504 counter

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/03/7 ADCY 11/03/07

Picklist Print

Friday, February 25, 2011 2:18:00 PM

Page 1

Work Order ID: 66764



Parent Item: D2535



Parent Item Name: Spring



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 50.00

Required Qty: 50.00

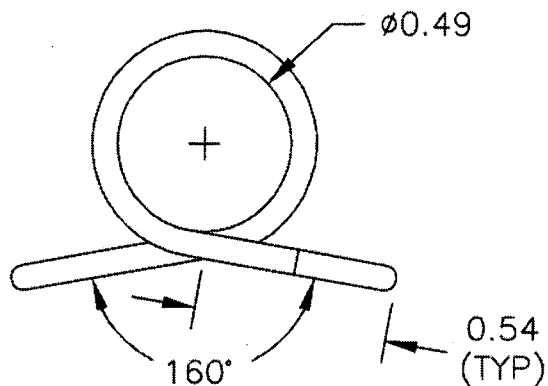
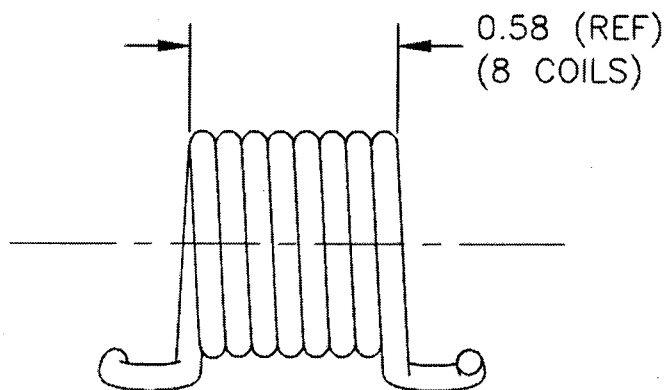
Comments: IPP A ☐ 99.04.19 ☐ New Issue (From hand written IPP) ☐ DM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P  Spring		Purchased	No			100	Each	0.0000	1 	50		<i>Rev 1/3/4</i> <i>(50)</i>	



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

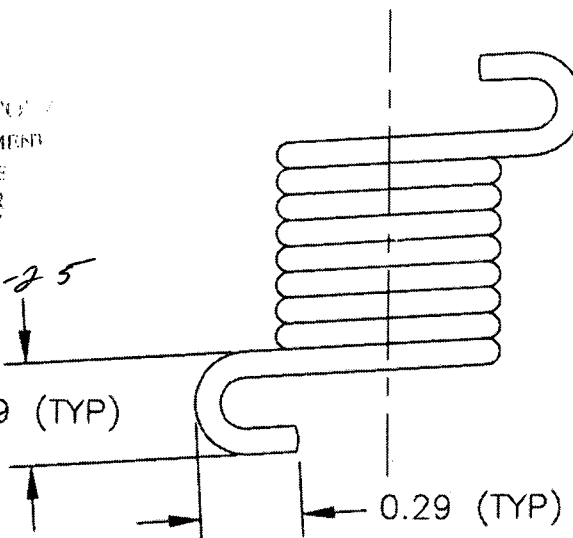
RELEASED
99.05.11 RE



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44764

PL 11-02-25

0.29 (TYP)



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13566

Purchase Order Date 2/28/2011

PO Print Date 2/28/2011

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name
Vendor Phone 866 230 5312
Vendor Fax 866 230 5338
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

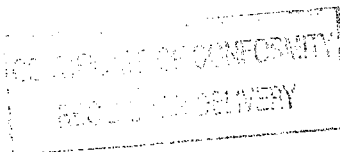
Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
2/28/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	3/7/2011 Yes	50.00 Each	FedEx PI collect	\$4.5600	\$228.00

Special Inst: AS PER DWG D2535 REV. A
B66764
VICTORY SPRING: 0.070 SS TORSION
SPRING

PO Total: \$228.00



No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 2/28/2011



convenient. consistent. correct.

PACKING SLIP

22016

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
3-Mar-11		<u>PO13566</u>		Fedex 151793240	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
<u>50</u>	<u>D2535P Spring</u> 8.11.03/07 x54				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 3/3/2011
PART/DRAWING #: D2535P Spring	PO # PO13566
SPRING DESCRIPTION: Torsion	QUANTITY: 50

8 x 103/10 → (754)

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.070	0.072	per previous orders
Coil I.D.	0.490	0.502	
Coil O.D.			
Number of Coils	8 ref	7.9	
Free Length			
Helix	RHW	yes	
End type	per DWG.	yes	
Deburr End			

COMMENTS

Mill Certificate attached: yes
Material Heat Number: E73133

Inspected by: *Jeremy Burrows*

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 3/3/2011																																						
PART/DRAWING #: D2535P	PO # <u>PO13566</u>																																						
SPRING DESCRIPTION: Torsion	QUANTITY: 50																																						
MATERIAL GRADE: T302 <u>Stainless Steel Wire Spring</u> ASTM-313-03																																							
<p>PROPERTIES:</p> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><u>Chemical</u></p> <p style="text-align: right; margin-right: 20px;">8.13/07 (K54)</p> <table> <tr><td>Carbon:</td><td>(C)</td><td>0.080</td></tr> <tr><td>Chromium:</td><td>(Cr)</td><td>17.500</td></tr> <tr><td>Copper:</td><td>(Cu)</td><td>0.320</td></tr> <tr><td>Manganese:</td><td>(Mn)</td><td>1.240</td></tr> <tr><td>Molybdenum:</td><td>(Mo)</td><td>0.230</td></tr> <tr><td>Nickel:</td><td>(Ni)</td><td>8.010</td></tr> <tr><td>Nitrogen:</td><td>(N)</td><td>0.040</td></tr> <tr><td>Phosphorus:</td><td>(P)</td><td>0.032</td></tr> <tr><td>Silicon:</td><td>(Si)</td><td>0.380</td></tr> <tr><td>Sulphur:</td><td>(S)</td><td>0.006</td></tr> </table> </div> <div style="width: 45%;"> <p><u>Physical</u></p> <table> <tr><td>Size:</td><td>.072"</td></tr> <tr><td>Tensile:</td><td>256,000</td></tr> <tr><td>Hardness:</td><td></td></tr> <tr><td>Heat #</td><td>E73133</td></tr> </table> </div> </div>		Carbon:	(C)	0.080	Chromium:	(Cr)	17.500	Copper:	(Cu)	0.320	Manganese:	(Mn)	1.240	Molybdenum:	(Mo)	0.230	Nickel:	(Ni)	8.010	Nitrogen:	(N)	0.040	Phosphorus:	(P)	0.032	Silicon:	(Si)	0.380	Sulphur:	(S)	0.006	Size:	.072"	Tensile:	256,000	Hardness:		Heat #	E73133
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Certified by: Jeremy Burrows

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.